

Work Order ID 132405

132405

Page 1

May-07-15 2:40:21 PM

Item ID: D4271-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Beam Assy, Aft
 Start Date: 5/07/15 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/07/15 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: *h* Date: Tooling: Date: Run Start ***NR1***
 QC: Date: SPC (Y/N): Date: Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D4271	D

100		0.00							
100									
Small Fab	Memo	0.00							
Small Fab	1- Pick and Assemble as per dwg								

110	QC5- Inspect part completeness to step on W/O	0.00							
110									
QC	Memo	0.00							
Quality Control									

120	Identify as per dwg & Stock Location: <u> <i>st 43</i> </u>	0.00							
120									
Packaging	Memo	0.00							
Packaging									

DAS
36
9-89

DAS
38
9-89

MAY 12 2015

DAS
27
9-89

MAY 14 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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							Lead hand / Supervisor Approval Verification																		
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Root Cause		FAULT CATEGORY																							
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Work Order ID 132405***132405***

Page 2

Item ID: D4271-013

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Beam Assy, Aft

Stop ***NS2***

Start Date: 5/07/15 Start Qty: 1.00

1

Cust Item ID:

Required Date: 5/07/15 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

MLJ MAY 15 2015

MLJ MAY 14 2015

DQA: _____ Date: _____



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Misidentified ☐	Past Due ☐																								

Picklist Print

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Page 1

2

Work Order ID: 132405

132405

Parent Item: D4271-013

D4271-013

Parent Item Name: Beam Assy, Aft

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP rev:A 10.11.18 new issue DD verf:EC
11.01.26 RevB dwg EC verified by:DD
per rev PD1 EC verified by:JLM

IPP RevB
IPP RevC 11.07.20

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4271-027 *D4271-027* End Fitting Assembly Aft Beam		Manufactured	No			100	Each	1.0000	1	1		15/05/12	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST375				1					
					131851			1					
D4276-1 *D4276-1* Aft Beam		Manufactured	No			100	Each	2.0000	1	1		15/05/12	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				ST463				2					
					123079			2					
AN3C12A *AN3C12A* Bolt		Purchased	No			100	Each	216.0000	6	6		15/05/12	DAS 36 9-89
				<u>Location</u>				<u>Loc Qty</u>					
				GA				137					
					M128727			137					
				ST349				79					
					M128727			79					

DQA: _____ Date: _____

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132405

Parent Item: D4271-013

D4271-013

Parent Item Name: Beam Assy, Aft

Start Date: 5/07/15

Required Date: 5/07/15

Start Qty: 1.00

Required Qty: 1.00

MS21043-3

Purchased

No

100

Each

791.0000

6

6

MS21043-3

Nut

DAS
36
9-89

15/05/12

Location

Loc Qty

Loc Code

FG	80	
103691	80	
FP001	65	
m130673	65	
GA	325	
m130673	15	
m131677	310	6
ST304	321	
m131340	321	

NAS1149C0332R

Purchased

No

100

Each

2,869.000

12

12

NAS1149C0332R

WASHER

DAS
36
9-89

15/05/12

Location

Loc Qty

Loc Code

FP001	2140	
m130325	2140	
GA	642	
m131618	642	12
ST260a	87	
m131697	87	

DQA: _____ Date: _____



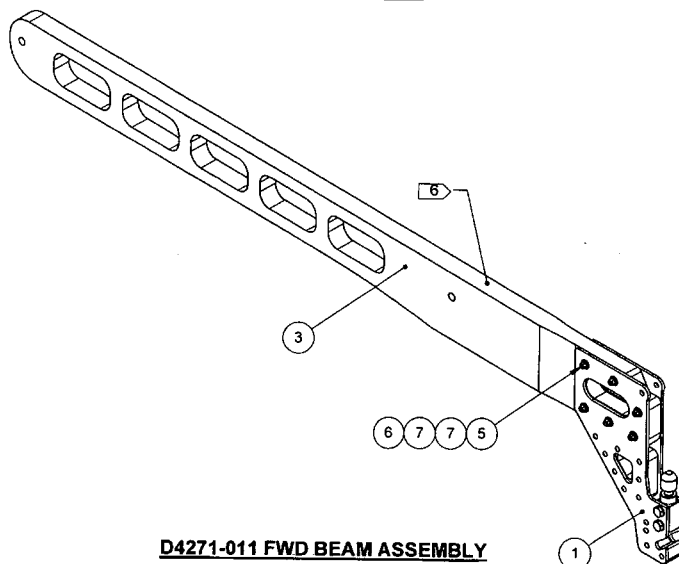
WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

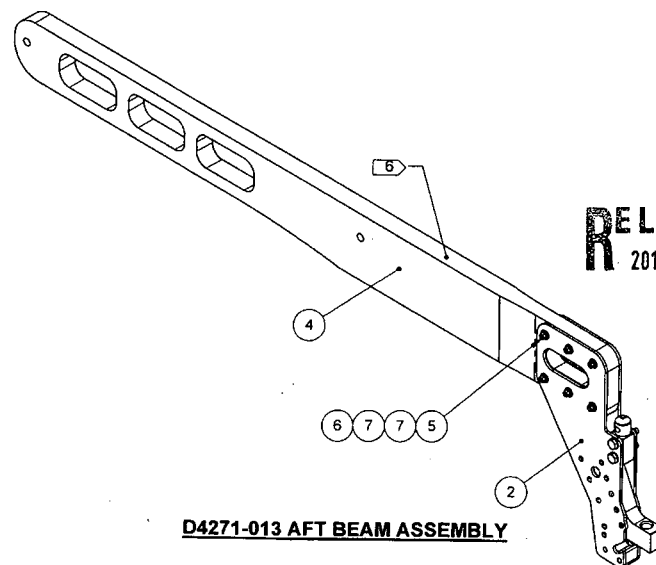
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<table style="width: 100%; border: none;"> <tr> <td colspan="2" style="text-align: center; vertical-align: top;"> Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐ </td> <td colspan="3" style="text-align: center; vertical-align: top;"> FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐ </td> </tr> <tr> <td colspan="3" style="text-align: center; vertical-align: top;"> Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐ </td> </tr> <tr> <td colspan="3" style="text-align: center; vertical-align: top;"> OTHER : ☐ </td> </tr> </table>					Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabelled ☐ Fit/Function ☐ Misaligned/off center ☐			Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			OTHER : ☐								
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ITEM	QTY -011	QTY -013	P/N	DESCRIPTION
	X		D4271-011	FWD BEAM ASSEMBLY
		X	D4271-013	AFT BEAM ASSEMBLY
	-	-	D4271-021	DELETED AT REVISION D
	-	-	D4271-023	DELETED AT REVISION D
1	1	-	D4271-025	FWD BEAM END FITTING ASSEMBLY
2	-	1	D4271-027	AFT BEAM END FITTING ASSEMBLY
3	1	-	D4275-1	FWD BEAM
4	-	1	D4276-1	AFT BEAM
5	6	6	AN3C12A	BOLT
6	6	6	MS21043-3	NUT
7	12	12	NAS1149C0332R	WASHER



D4271-011 FWD BEAM ASSEMBLY



D4271-013 AFT BEAM ASSEMBLY

RELEASED
2011-07-28

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART IDENTIFY WITH DART P/N "D4271-0XX" AND B/N "BXXXXX"
PER DART QSI 044 6.1 (FINE POINT MARKER)
- 7) WEIGHT -011: 11.02 lbs
-013: 12.97 lbs

D	DELETED -021 & -023 REPLACED BY -025 & -027 FOR Q.R. STEP INSTALLATION.	AJS	11.07.14
C	ADDED -021 & -023 FOR EASE OF CONFIGURATION MANAGEMENT. REFORMAT SEE PREV REV FOR DETAILS.	AJS	11.07.12
B	ITEM 10 CHANGED FROM AN3C12A TO AN4C13A	SC	10.12.01
A	NEW ISSUE	SC	10.11.25
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH		
DRAWN	AJS		
CHECKED	GP		
MFG. APPR.	E		
APPROVED	MD		
DE APPR.	MD		
DATE	11.07.14		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D4271** REV. D
SHEET 1 OF 3
TITLE **SUPPORT BEAM ASSEMBLIES** SCALE NTS

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